Work Order ID Monday, April 11, 2011										Page 1
Item ID: D3492-0 Revision ID:	253		Accept				5	Setup S	,,,,	
Item Name:Plug AssetStart Date:4/11/201Required Date:4/25/201Reference:	1 Start Qty: 30.00			Cust Item Customer						
Approvals: Process	Plan: MF	Date: 11-04-11	Tooling:		Date:		I		4000	
QC:		Date:	SPC (Y/N):	I)ate:			3	top	
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	t Reject Number	Insp. Stamp
	Revision Nbr	***************************************	`							
Hardinge CNC Lathe Small	Hardinge CNC LATHE S Memo I-Tum as pe Rev: N	tr Folio FA715 & Dwg D34	0.00 0.00 92∃Dwg Rev:	S□Folio			30	Ø	/-	
QC Quality Control	QC2- Inspect parts off m Memo	achine FAI/FAIB	0.00 0.00 (1) 6) (30	J.	/ 	
120 	QC8- Inspect parts - seco	and check	0.00	29 11 ·	C ·	1	ZD	p		

Quality Control

Dart Aerosp	pace Ltd
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W/O:			V	ORK ORDER CHANGE							
DATE	STEP	PROC	CEDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
								-			
								,			
Part No					NCR: Yes No DQA: Date:						
				ion:				Date: _			
NCR:		W	ORK OR	DER NON-CONFORMA	NCE (NCF	R)					
DATE	STEP	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval		
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	k Section		Chief Eng	QC Inspector		
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Monday, April 11, 2011 1:44:26 PM

Item ID:

D3492-053

Revision ID:

Item Name:

Start Date:

4/11/2011

Plug Assembly

Start Qty: 30.00 Req'd Qty: 30.00



Accept

Setup Start



Stop

Required Date: 4/25/2011

Cust Item ID: **Customer:**

Reference:

Approvals:

Process Plan:

QC:

Date: _____

Date: _____ Tooling:

SPC (Y/N):

Tool ID

Date:

Date:

Start



Stop

Sequence ID/

Work Center ID

130

Small Fab

Small Fab

Operation Description

Small Fab

Memo

1-Deburr

Set Up/ **Run Hours**

0.00

Tool # Plan Qty Code

Reject Accept Qty

Run

Reject Number

Insp. Stamp

140

OC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

Memo

150



Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

30

Al ilouloz

0.00

Dart	Aeros	pace	Ltd

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W/O:			WO	RK ORDER CHANG	ES				,		
DATE	STEP	PRO	CEDURE CHAI	NGE	Ву	D	ate Qt	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
						•					
	·				`						
									·		
		PAR #:	Fault Category: N			NCR: Yes No DQA: Date					
Resolution:			Disposition	n:	_ QA: N/C	Close	ed:	Date: _	· .		
NCR:		\	WORK ORDE	ER NON-CONFORMA	NCE (N	CR)					
DATE	STEP	Description of NC		on B	0	Verificatio		Approval			
- DAIL	OTE:	Section A	Initial Chief Eng	Action Description Chief Eng	Di	n & ate	Section C	Chief Eng	QC Inspector		
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		·									
							*. :				

Work Order ID 68322

Monday, April 11, 2011 1:44:26 PM



Page 3

Item ID:

D3492-053

Accept

Setup Start

Stop



Revision ID:

Plug Assembly Item Name:

Required Date: 4/25/2011

Start Date:

4/11/2011

Start Qty: 30.00

Req'd Qty: 30.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/

Work Center ID

160

Powdercoat

Powder Coating

Operation Description

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Set Up/ Run Hours

0.00

Tool ID

Tool # Plan

Accept Qty

Code

Reject Qty

Reject Insp. Number

Stamp

(Flat End Only)□START TIME:

170



Quality Control

OC3-Inspect Part Finish

Memo

0.00

0.00

30 o Al Mod 15

Packaging

Memo

Identify as per dwg & Stock Locat

0.00

30× ØM/11/06/15

180

Packaging

W/O:		WORK ORDER CHANGES											
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date G	Approval Chief Eng /	Approval QC Inspector					
							Prod Mgr	QC inspector					
		•											
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA: _	Date: _						
Resolution:			Dispositio	n:	QA: N/C Cld	closed: Date:							
NCR:		,	WORK ORD	ER NON-CONFORM	IANCE (NCR)							
		Description of NC			ection B	Verificati	on Approval	Approval					
DATE	STEP Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		QC Inspector						
	1												
	,												

Work Order ID 68322

Monday, April 11, 2011 1:44:26 PM



Page 4

Item ID:

D3492-053

Accept



Setup Start

Stop



Revision ID:

Item Name:

Plug Assembly

Start Date:

4/11/2011

Start Qty: 30.00

Req'd Qty: 30.00



Cust Item ID: Customer:

Reference:

			_	
A	ppr	ova	ls:	

QC:

Process Plan:

Operation

Description

Date:

QC21- Final Inspection - Work Order Release

Date:

Tooling: SPC (Y/N):

Date: Date: Run

Start

Stop



Sequence ID/

Work Center ID

Required Date: 4/25/2011

190

Run Hours

Set Up/

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

Quality Control

Memo

0.00.

Dart Aerospace Lt

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W/O:			WC	RK ORDER CHANG	GES			•	
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date (Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No: PAR #:									
	Re	esolution:					Date: _		
NCR:		`	WORK ORD	ER NON-CONFORM	ANCE (NCR)			
DATE	STEP	Description of NC			ction B	Verificat		Approval	
DAIL	0121	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	C Chief Eng	QC Inspector	
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						I		I	

Picklist Print

Monday, April 11, 2011 1:44:22 PM

Work Order ID: 68322

Parent Item:

D3492-053

Parent Item Name: Plug Assembly



Start Date: 4/11/2011

Required Date: 4/25/2011

Start Qty: 30.00

Required Qty: 30.00

Comments:

IPP Rev:A New Issue

06-06-20 JLM

IPP Rev:B as per Rev C 07-12-06 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750		Purchased	No			100	f	8.5630	0.0458	1.446316			
										S	11/6	(11	

6061-T6 Round Bar .750"

Location	Loc Qty	Loc Code	
MAT013	8.563		
112442	0.796		
116406	7.767		
117481			1.81

W/O:	WORK ORDER CHANGES								
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								Prod Wgr	,
									:
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		·							
Part No:		PAR #:	Fault Cate	egory:	_ NCR: Yes	No DQ	A:	Date:	
Resolution: Disposition:				n:	QA: N/C (losed:		Date: _	
NCR:		1	WORK ORD	ER NON-CONFORM	ANCE (NC	R)			
D47F	OTED	Description of NC Corrective Action			tion B	Verifi	cation	Approval	Approval
DATE	STEP Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sec	tion C	Chief Eng	QC Inspector	
									,

DART AEROSPACE LTD	Work Order:	68322 "
Description: The	Part Number:	グライバーマ
Inspection Dwg: NYIL, Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	x	First Artic	le X	Proto	type	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Rejest	Method of Inspection	Comments
-060	T.005	061			37.9	
,060	±-005	-060				
-500	-,070	100				
000 x 2000	+-010	1050x26°	,			
0,750	~~010	\$ 745				
0-520	£-01/0	\$-510				
-045	4.000/7.002	044				
-090	1-000/-002					,
		-				
				·		
						,
			1			
	,					

Measured by:	Audited by:	Prototype Approval:	
Date: (1)	Date: 11 C 1	Date:	

Rev	Date -	Change	Revised by	Approved
А		New issue	KJ/JLM	

. . x

-NAS1611 O-RING (SEE TABLE) D3492-XX PLUG (SEE TABLE)-

D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	PART NUMBER	DESCRIPTION
X							D3492-041	PLUG ASSEMBLY
	X						D3492-043	PLUG ASSEMBLY
		Х					D3492-045	PLUG ASSEMBLY
			Х				D3492-047	PLUG ASSEMBLY
				X			D3492-049	PLUG ASSEMBLY
					X		D3492-051	PLUG ASSEMBLY
						Х	D3492-053	PLUG ASSEMBLY
1							D3492-1	PLUG
	1						D3492-3	PLUG
		1					D3492-5	PLUG
			1				D3492-7	PLUG
				1			D3492-9	PLUG
					1		D3492-11	PLUG
						1	D3492-13	PLUG
		1					NAS1611-005	O-RING
			1				NAS1611-007	O-RING
1							NAS1611-010	O-RING
						1	NAS1611-012	O-RING
	1						NAS1611-013	O-RING
					1		NAS1611-015	O-RING
	İ			1			NAS1611-016	O-RING

NOTES: 1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

D	INCORPORATED DEO D3492-C-1. SHT 2 DIM C FOR -1 WAS 0.055. (SEE CAR11-048)	AJS	11.05.24
С	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
В	ADD -047; UPDATE DIM A FOR -045	PH	06.05.11
Α	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE

DESIGN	PH	_ DART AEROSPACE LTD				
DRAWN	AJS	HAWKESBURY, ONT	ARIO, CANADA			
CHECKED	<u>_</u>	DRAWING NO.	REV. D			
MFG. APPR.	JER	D3492	SHEET 1 OF 2			
APPROVED	V/25.	TITLE	SCALE			
DE APPR.	7	PLUG	2:1			
DATE 11.0	15 24	COPYRIGHT © 2007 BY DA				

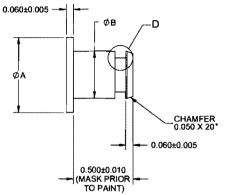
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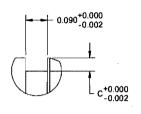
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W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHANGE			у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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						- 3				
Part No	*	PAR #:	Fault Cate	egory:	_ NCR:	Yes N	o DQ /	A:	Date: _	
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DATE	STEP	Description of NC	Corrective Action Section			Veritic			cation Approval	Approval
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date	Secti	on C	Chief Eng	QC Inspector
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[·] H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

-POWDER COAT THESE FACES ONLY PER NOTE 2



D3492-XX PLUG



DETAIL D



D

D3492-XX PLUG MACHINING DETAILS

	P/N	Α	В	C	MATERIAL SPEC	
	D3492-1	0.625	0.394	0.050	M6061T6R0.625	<u></u>
	D3492-3	0.750	0.582	0.045	M6061T6R0,750	
	D3492-5	0.375	0.188	0.045	M6061T6R0.375	
	D3492-7	0.500	0.270	0.045	M6061T6R0.500	
	D3492-9	0.938	0.750	0.045	M6061T6R1.000	
	D3492-11	0.850	0.664	0.045	M6061T6R0.875	
•	D3492-13	0.750	0.510	0.045	M6061T6R0.750	

NOTES:
1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: N/A 7) WEIGHT: N/A

DESIGN DART AEROSPACE LTD DRAWN AJS HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. D D3492 MFG. APPR. SHEET 2 OF 2 APPROVED TITLE SCALE **PLUG** DE APPR. 4:1 COPYRIGHT © 2007 BY DART AEROSPACE LTD

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HOT TO BE USED FOR ANY PURPLESS ON COPED ON COMMUNICATION TO MAY OTHER PERSON WITHOUT DATE 11.05.24

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W/O:			M	ORK ORDER CHANG	ES .					
DATE	STEP	PRO	PROCEDURE CHANGE				Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No:		PAR #:	Fault Ca	tegory:	_ NCR: Yes	No DQ	DQA: Date:			
Resolution:			Disposition: Q			QA: N/C Closed:				
NCR:		\	WORK OR	DER NON-CONFORM	ANCE (NC	R)	1			
DATE	STEP	Description of NC Section A	_{n A} Initial Action Des		ion B Sign	& Sec	cation tion C	Approval Chief Eng	Approval QC Inspector	
			Chief Eng	Chief Eng	Dai					
		· ·								